

Work Order ID 61945-1

PRELIMINARY ISSUE



Page 1

Monday, September 13, 2010 8:18:41 AM

Item ID: D4172-10

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Angle

Start Date: 9/10/2010

Start Qty: 6.00



Cust Item ID:

Required Date: 9/17/2010

Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4172

PA1

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut to length as per dwg
2- Use DT9663 to drill holes in angle, open to size as per dwg
3- Deburr holes

110

QC5- Inspect part completeness to step on W/O

0.00 - inspecting to PA1



QC

Memo

0.00

Quality Control

Dy only
Scolerku X6

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/09/16

X6

9/10/09/16 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61945

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Page 2

Item ID: D4172-10

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Stop



Item Name: Angle

Start Date: 9/10/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

10-9-16

0.00

Memo

6

7

140



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

JAN CT

0.00

Memo

10-09-23 5

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/09/29

POSITIVE RECALL

EFFECTIVE 09-13 AUTH

RELEASED DATE 10-09-24

10-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 8:18:45 AM

Page 1

Work Order ID: 61945

Parent Item: D4172-10

Parent Item Name: Angle




Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6203  Angle Extrusion		Manufactured	No			100	f	9.5000	0.0625	0.394737			

Location

MAT

45501

Loc Qty

9.5

9.5

Loc Code



Handwritten: 9/10/09/15
0.394737

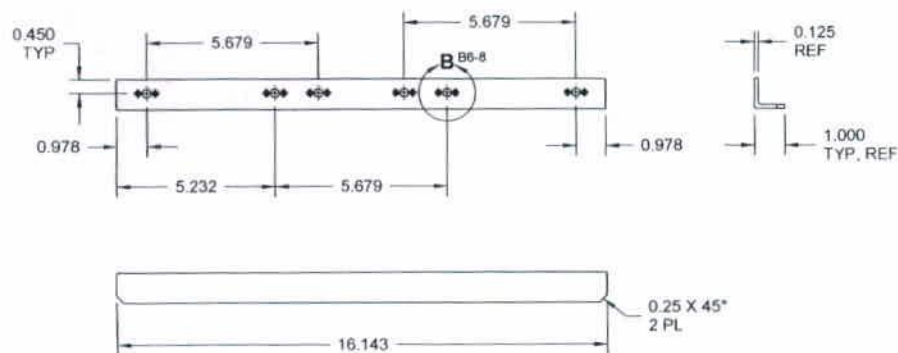
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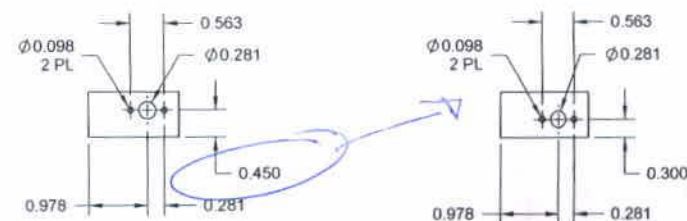
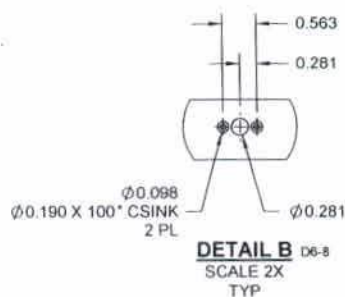
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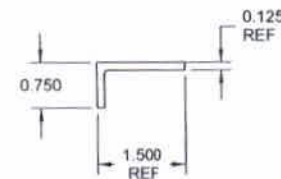
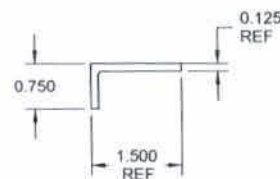


D4172-7 CROSSBAR



D4172-9 ANGLE

D4172-10 ANGLE



NOTES:

1) MATERIAL

D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6207

D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1

7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A MEMORANDUM
WITHOUT NOTICE
WORK ORDER
NO. 41945
B-10-9-13

PRELIMINARY ISSUE
10.09.08

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA1
MFG. APPR.		D4172 SHEET 8 OF 8
APPROVED		TITLE SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD
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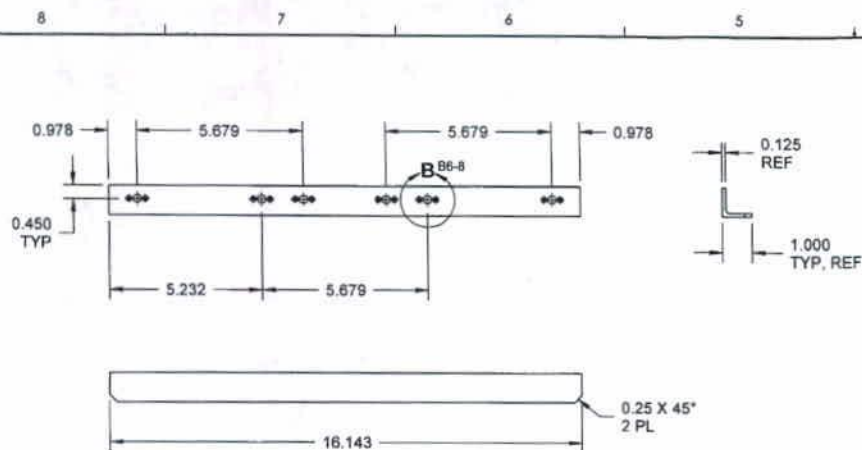
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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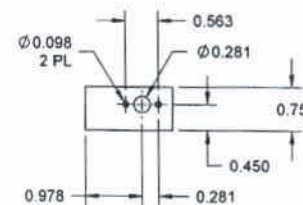
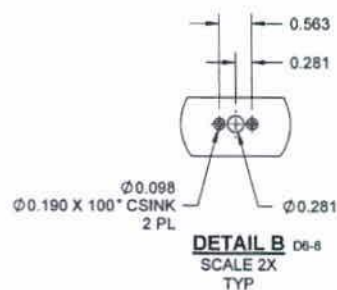
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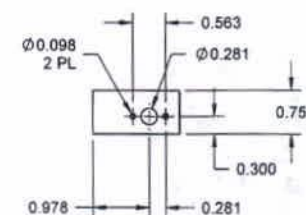
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D4172-7 CROSSBAR






D4172-9 ANGLE



D4172-10 ANGLE

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REF. DART SPEC. M8061T6A OR D6203
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR		D4172	SHEET 7 OF 7
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DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-09-29

61945